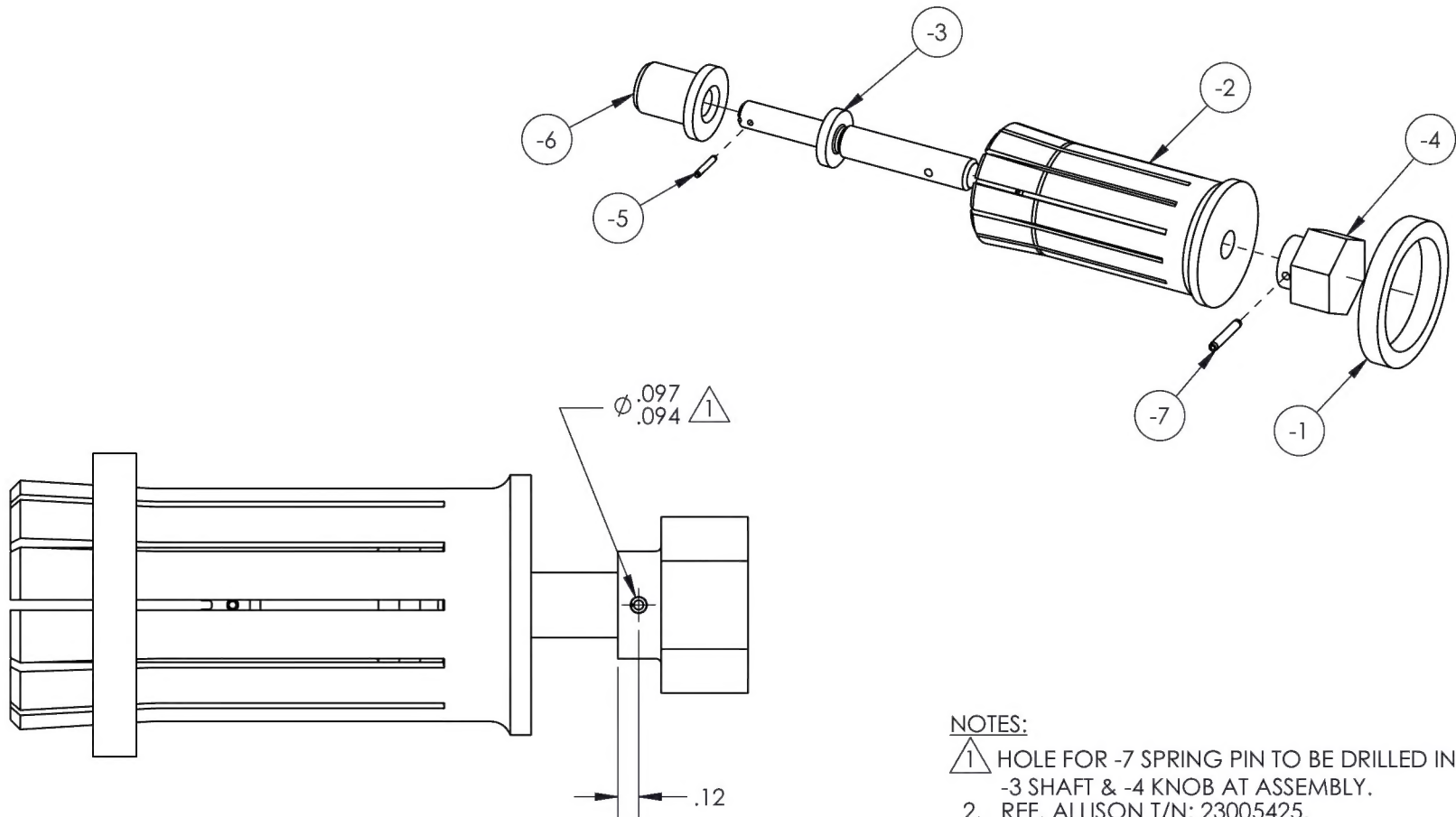


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0168	-2 CH'D SLOT DETAIL ADDED (12X R1.50) SEE SECTION E-E. -6 ADDED HEAT TREAT RC 36-40.	10/30/2014	RJC	JAG

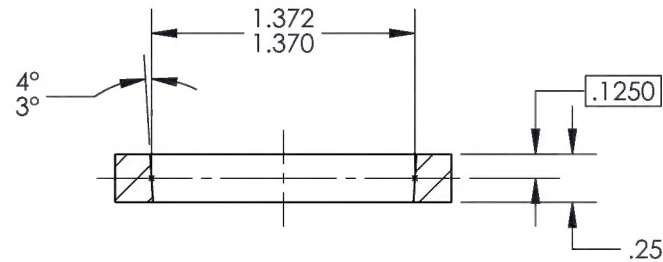
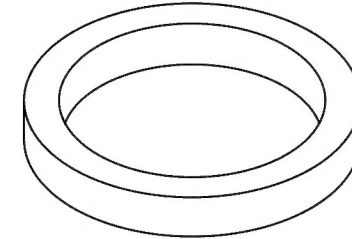
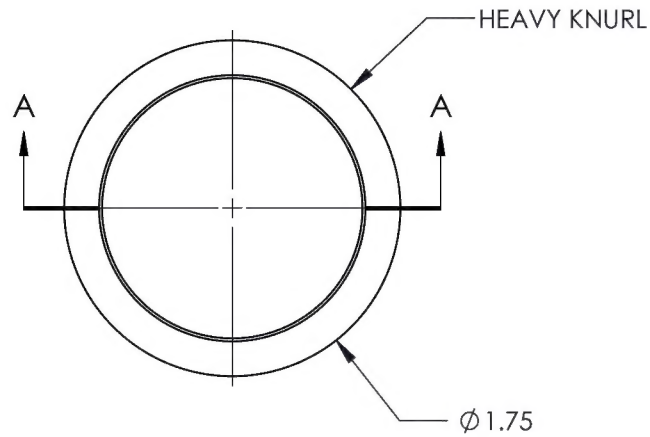


1. HOLE FOR -7 SPRING PIN TO BE DRILLED IN
-3 SHAFT & -4 KNOB AT ASSEMBLY.
2. REF. ALLISON T/N: 23005425.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	INNER RACE				
									DWG NO.	RB23005425			REV 1
			-1	1	RETAINER	4140	Ø1-7/8 X 3/8	2	MAT'L	DRAWN BY: DUERFELDT			
			-2	1	FRAME	4140	Ø1-5/8 X 3-1/8	3	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>R. Clough</i>		
			-3	1	SHAFT	4140	Ø7/8 X 3-1/8	4	.XXX ± .010	FRACTIONS ± 1/8		HEAT TREAT	
			-4	1	KNOB	12L14	7/8 HEX X 7/8	5	.XX ± .02	ANGLES ±.5°		FINISH	
		B/O	-5	1	SPRING PIN	STEEL	Ø1/16 X 7/16 MCMaster-CARR #90692A084	1	.X ± .1	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		SPEC	
			-6	1	BUSHING	4140	Ø1 X 1	6	2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL		
		B/O	-7	1	SPRING PIN	STEEL	Ø3/32 X 5/8 MCMaster-CARR #90692A145	1	SCALE 1:1	DATE 9/2/2014	SHEET 1 OF 6		

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



SECTION A-A

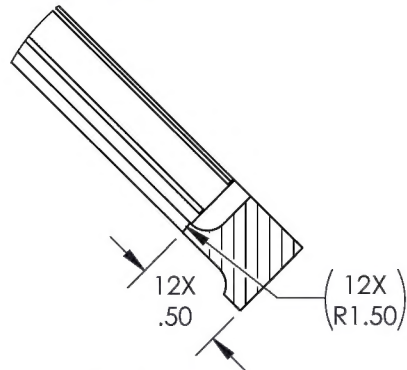
①

RETAINER

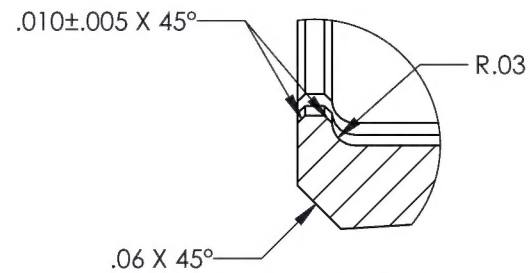
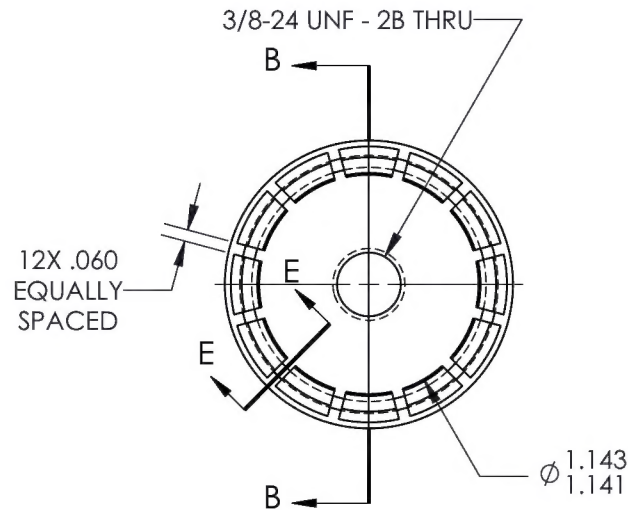
DART AEROSPACE	
TITLE PULLER - No. 2 V2 BEARING INNER RACE	
DWG NO. RB23005425-1	REV 1
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>R. Clough</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 36-40
.XX ± .02 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 9/2/2014
SHEET 2 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0168	-2 CH'D SLOT DETAIL ADDED (12X R1.50) SEE SECTION E-E.	10/30/2014	RJC	JAG

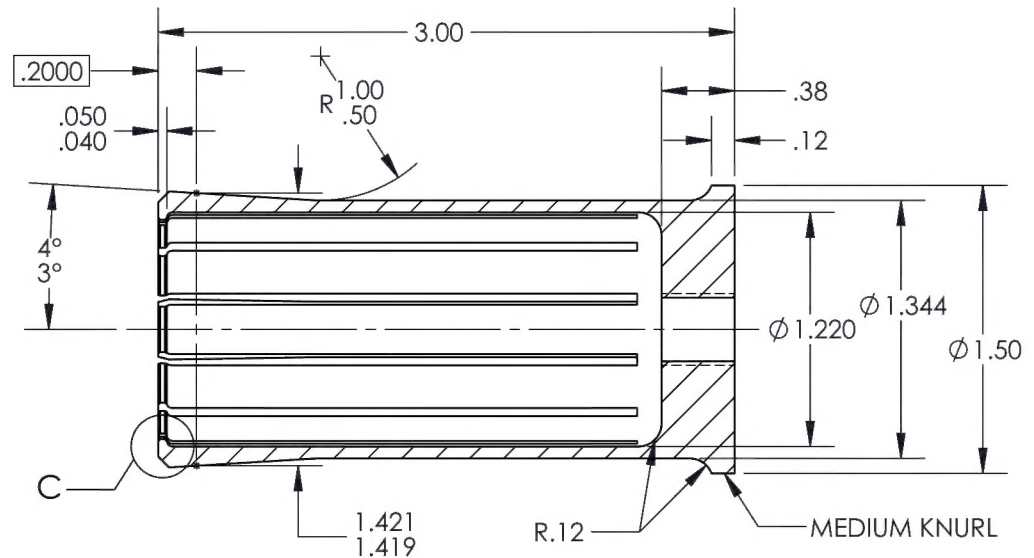


SECTION E-E



DETAIL C
SCALE 4 : 1

(-2)
FRAME

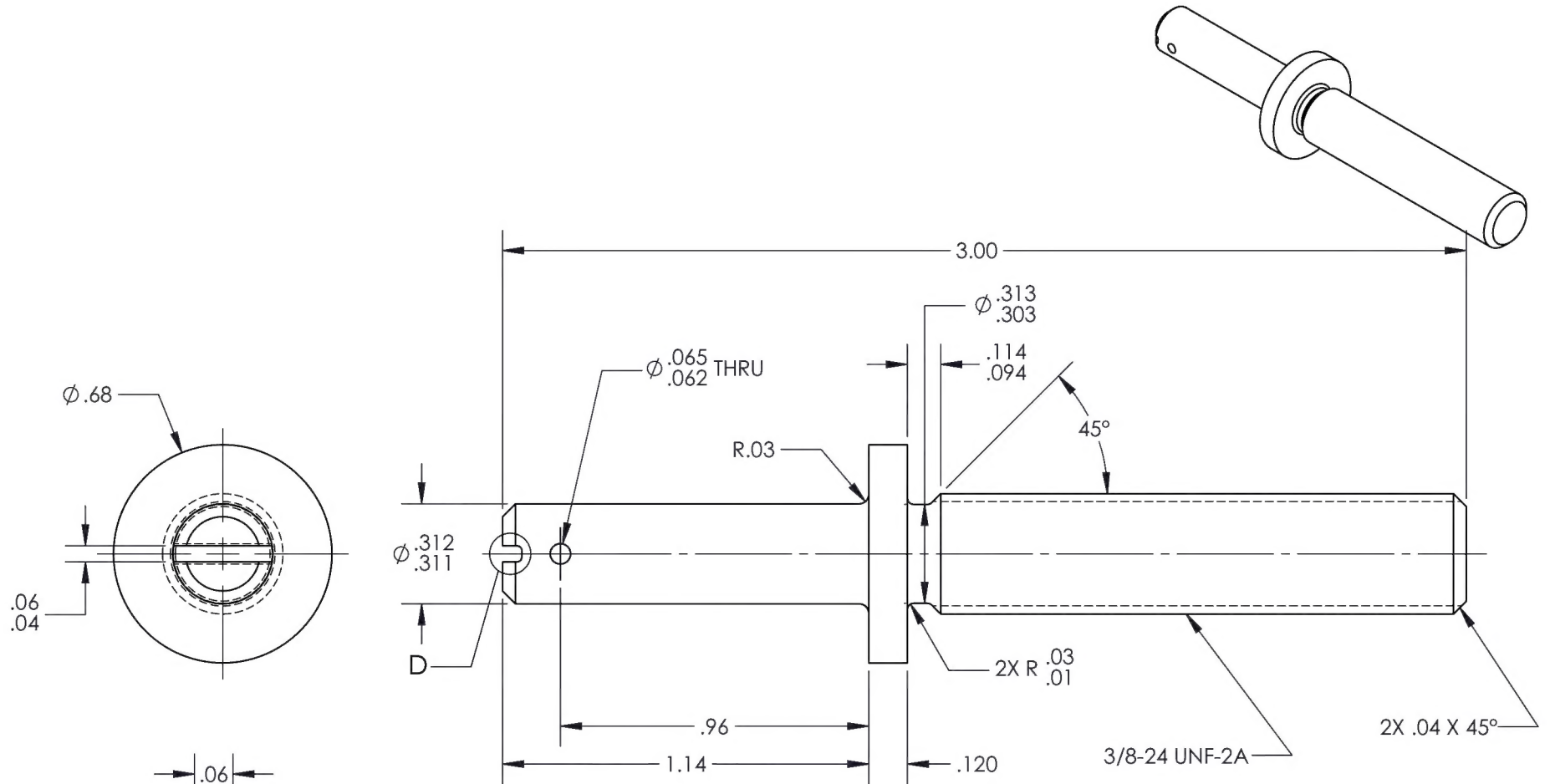


SECTION B-B
HIDDEN LINES REMOVED
FOR CLARITY

DART AEROSPACE	
TITLE PULLER - No. 2 V2 BEARING INNER RACE	
DWG NO. RB23005425-2	REV 1
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>R. Plough</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 36-40
.XX ± .02 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 9/2/2014
SHEET 3 OF 6	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



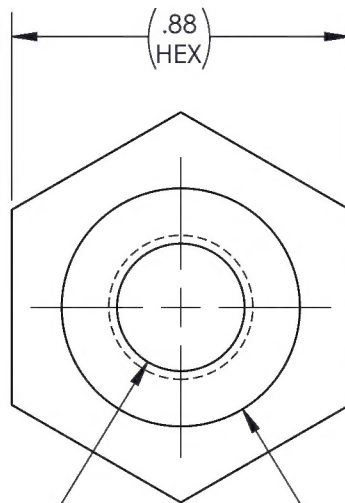
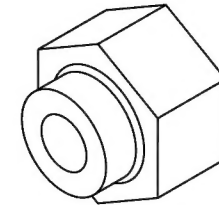
DETAIL D
SCALE 4 : 1

(-3)
SHAFT

DART AEROSPACE	
TITLE PULLER - No. 2 V2 BEARING INNER RACE	
DWG NO. RB23005425-3	REV 1
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>R. Clough</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 36-40
.XX ± .02 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 9/2/2014
SHEET 4 OF 6	

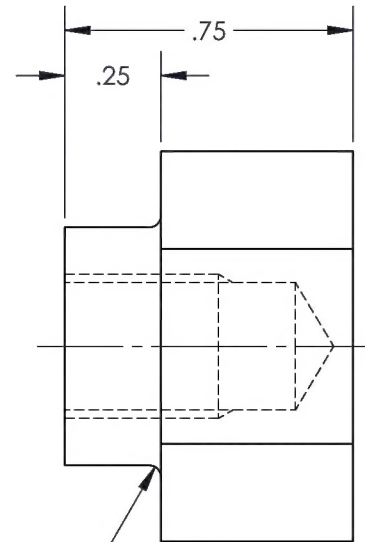
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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



$\phi .33 \nabla .60 \text{ MAX}$
3/8-24 UNF - 2B $\nabla .40 \text{ MIN}$

$\phi .62$



R.03

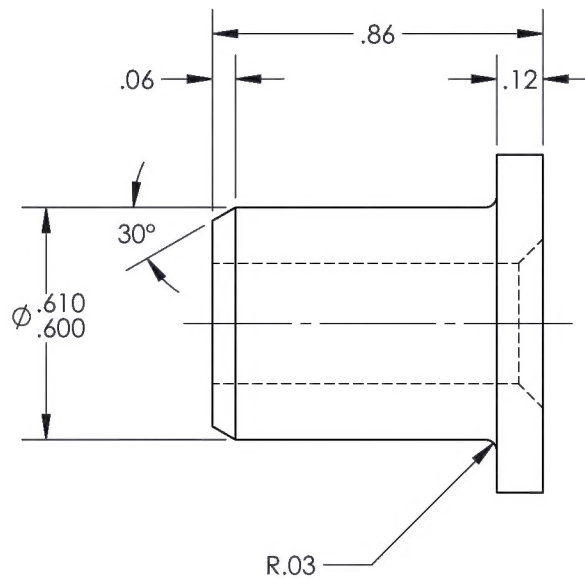
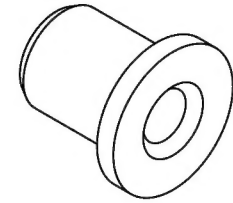
(-4)

KNOB

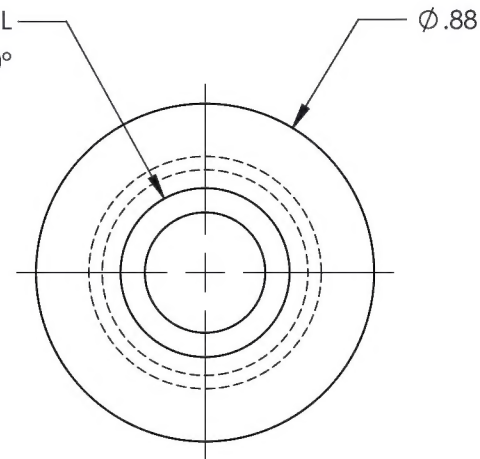
DART AEROSPACE	
TITLE PULLER - No. 2 V2 BEARING INNER RACE	
DWG NO. RB23005425-4	REV 1
MAT'L 12L14	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>R. Clough</i>
.XXX $\pm .010$	HEAT TREAT
.XX $\pm .02$	FINISH BLACK OXIDE
.X $\pm .1$	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 9/2/2014
SHEET 5 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0168	-6 ADDED HEAT TREAT RC 36-40.	10/30/2014	RJC	JAG



Ø .314 THRU ALL
✓ Ø .44 X 90°



(-6)

BUSHING

DART AEROSPACE	
TITLE PULLER - No. 2 V2 BEARING INNER RACE	
DWG NO. RB23005425-6	REV 1
MAT'L 4140	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>R. Clough</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT RC 36-40
.XX ± .02 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 9/2/2014
SHEET 6 OF 6	